

5/28/2018

LAKLE FAB

[Dart Hawkesbury] Job Sheet - David, Logan



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBEM262V3000101-1
Job Sheet 178192



Part No: RBEM262V3000101-1

Job Qty: 6 ea

Part Name: Frame Weldment



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 5/28/18

Job Tracking No:

Due Date: 7/9/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBEM262V3000101 Rev. 1 IPP Rev. A 18.05.14 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	7/9/18	7/9/18	0.00	0.00	Start Up Small Fab-2		12
110	Large Fab	6 pcs	7/9/18	7/9/18	0.00	6.00	Large Fab 3		12
115	QC	6 pcs	7/9/18	7/9/18	0.00	0.00	QC9		PD 15-08-03
120	QC	6 pcs	7/9/18	7/9/18	0.00	0.00	QC5		PD 16-03-03
130	Powdercoat	6 pcs	7/9/18	7/9/18	0.00	0.60	Powdercoat13		PD 18-08-03
140	QC	6 pcs	7/9/18	7/9/18	0.00	0.00	QC3		AUG 23 2018
180	Packaging	6 pcs	7/9/18	7/9/18	0.00	0.00	Packaging3		9-89
190	QC21-SA	6 Ea	7/9/18	7/9/18	0.00	0.00	QC21		MULL DAS 9-89

Part Op 110 - 1-Cut RBEM262V3000101-3/-5/-7/-9/-11/13. 2-Drill hole in -5. 3-Weld as per DWG.

Descriptions: 130 - ***Note***No Powder Coat in threaded holes. START TIME: 10:47 AM OVEN TEMPERATURE: 320°

FINISH TIME: 11:10 AM

140 - Ink stamp tool number

TEMPS: (0.17) BK 18-8-22

START: 3:05 O.V.T: 320° FINISH: 3:55

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBEM262V3000101-15	Gusset	12 Ea (2 ea)	90-Start up Operation	5093579
RBEM262V3000101-17	Main Plate	6 Ea (1 ea)	90-Start up Operation	5098402
M1018A2.500W.250	M1018A2.500W.250	6.6900 ft (1.115 ea)	110-Large Fab	5009407
M1018TS0.750W.070	M1018TS0.750W.070 order .065"	13.2000 ft (2.2 ea)	110-Large Fab	5088869

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBEM262V3000101-15	12	0	0
	RBEM262V3000101-17	6	0	0
110-Large Fab	M1018A2.500W.250	7	0	0
	M1018TS0.750W.070	13	0	0

Part Specifications

Specifications could not be found.

Plex 5/28/18 3:13 PM dart.logan.david

M1018A3.000W.250 X 1.115

5009407



Container No: S098512



Part: RBEM262V3000101-1

Job No: 178192

Serial No/Batch: S098512

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 08/02/18

RBEM262V3000101-1

S098512

225A
VNR
FAR

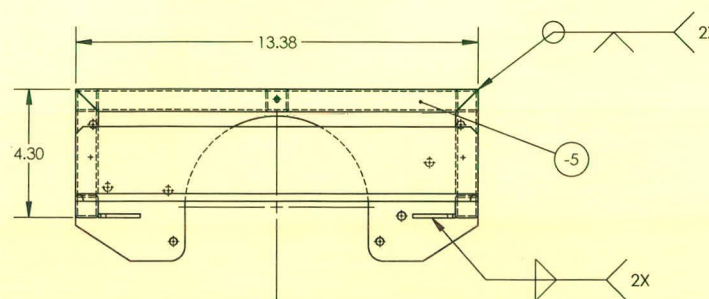
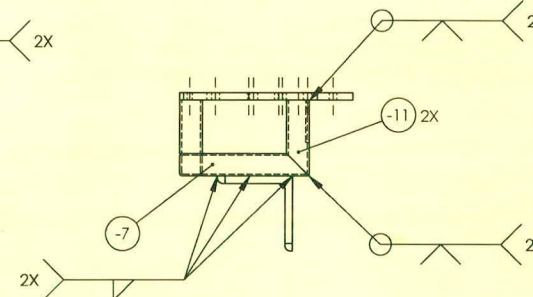
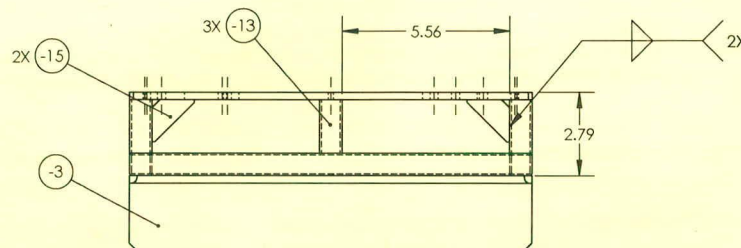
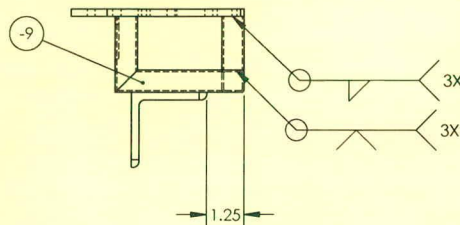
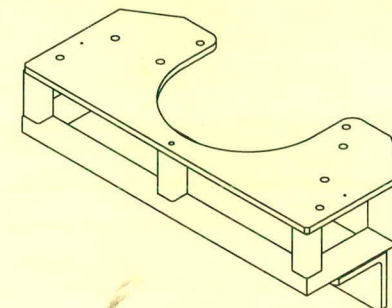
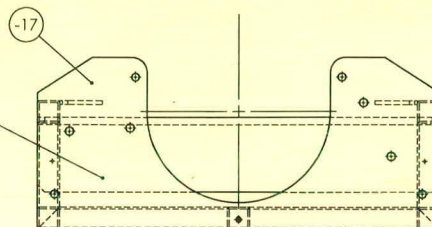
Aug 5 3 3018

225A VNR FAR

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR

REVISIONS			
REV	ECR	DESCRIPTION	DATE INITIAL APPROVED

INK STAMP T/N, S/N,
"MADE IN USA"



①
FRAME WELDMENT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 178192

20180712

NOTE:
NO POWDER COAT IN THREADED HOLES.

DART AEROSPACE	
TITLE EXTINGUISHING BOTTLE SUPPORT	
DWG NO. RBEM262V3000101-1	REV 1
MAT'L 6061-T6 ALUMINUM	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
FINISH POWDER COAT YELLOW	.XXX ± .010 FRACTIONS ± 1/8
SPEC FED #13538	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES ± 125
CHECKED BY DUERFELDT	1. BREAK ALL SHARP EDGES
APP'D BY CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED BY LINDSAY	USED ON MODEL
	H175
SCALE 1:4	DATE 6/20/2016
SHEET 2 OF 15	

